

Shg 26/06
Work Order ID 103378

103378

Page 1

June-24-13 10:30:42 AM

Item ID: E4662-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Co-Pilot Panel

Start Date: 6/24/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/25/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
E4662	A								

100

FLOW WATER JET

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2- Deburr if necessary

0 2 13-6-24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

1 2 13-6-24

Work Order ID 103378

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Page 2

June-24-13 10:30:42 AM

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N900040100

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NS1

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Start Date: 6/24/13

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Cust Item ID:

Required Date: 6/25/13

Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

Work Order ID 103378

103378

Page 3

June-24-13 10:30:42 AM

Item ID: E4662-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Co-Pilot Panel

Start Date: 6/24/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/25/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>ST</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

u 13-06-26

MLJ 13-06-26

u 13-06-26

Picklist Print

June-24-13 10:30:41 AM

Page 1

Work Order ID: 103378

Parent Item: E4662-1

Parent Item Name: Co-Pilot Panel

Start Date: 6/24/13

Required Date: 6/25/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.06.04 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	157.0094	2.3344	2.4572632			

Location

Loc Qty

Loc Code

MAT021

157.0093578

121473

0.9161578

123279

72.89

125257

51.2032

M126075

32

M0024T3S.125

M 123098

x 2-63

12 13-6-24

* matl not pulled.

DART AEROSPACE LTD	Work Order: 103378
Description: CO-Pilot Panel	Part Number: E4662-1
Inspection Dwg: E4662 Rev: A	Page 1 of 1

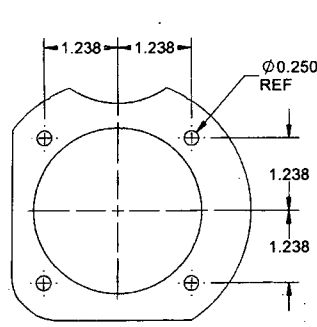
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.47		1.41	✓		V Skmol	
0.57		0.56	✓		"	
Ø 0.170		0.172	✓		"	
Ø 3.170		3.17	✓		"	
Ø 0.120		0.122	✓		"	
Ø 2.3		2.3	✓		"	
Ø 2.50		0.254	✓		"	
Ø 2.828		2.825	✓		"	
2.12		2.12	✓		"	
5		5	✓		"	
6.24		6.25	✓		"	
10.35		10.36	✓		T Skmol	
20.05		20.06	✓			
21.83		21.835	✓			
4.13		4.125	✓			
6.41		6.43	✓			
7.43		7.41	✓			
11.		11.01	✓			
13.24		13.25	✓			
13.52		13.53	✓			
15.40		15.41	✓			
0.125		0.126	✓			

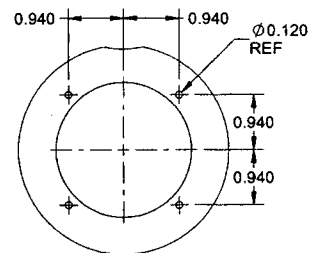
Measured by: [Signature]	Audited by: [Signature]	Preliminary Approval:
Date: 13-6-24	Date: 13 6 25	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

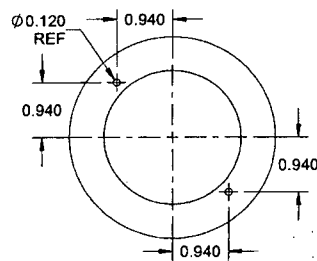
10.04.15



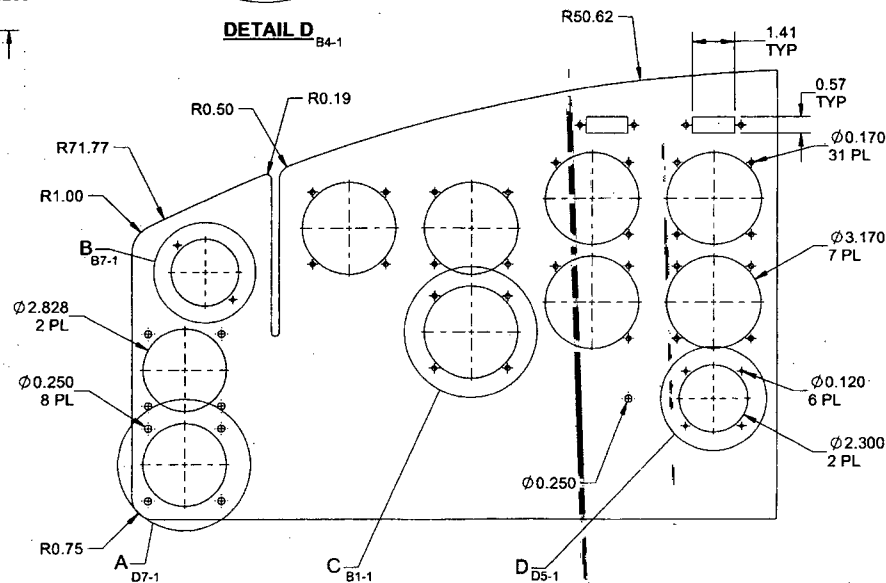
DETAIL A
B6-1



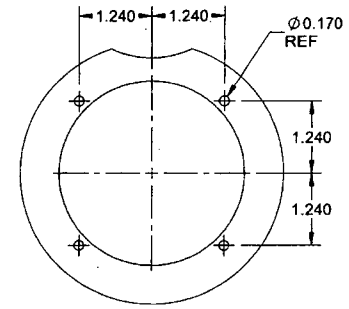
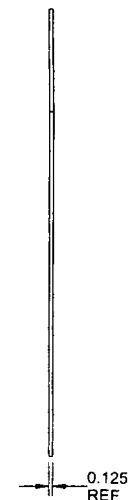
DETAIL D
B4-1



DETAIL B
C6-1



E4662-1 CO-PILOT PANEL



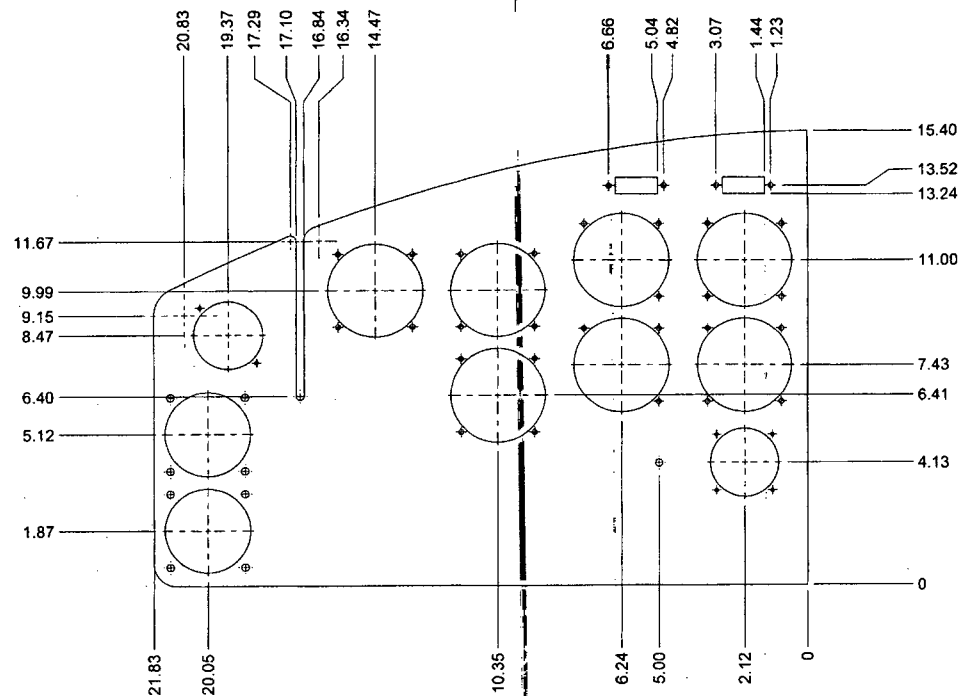
DETAIL C
B5-1

RELEASED
R 2012-06-01

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.125
OR
6061-T6/T62 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 2.60 lbs

A NEW ISSUE		DC	12.05.28
REV.	DESCRIPTION	BY	DATE
DESIGN	AB	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	BC		
CHECKED	AB	DRAWING NO.	REV. A
MFG. APPR.	BE	E4662	SHEET 1 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	N/A	INSTRUMENT PANEL	NTS
DATE	12.05.28	<small>COPYRIGHT © 2012 BY EAGLE COPTERS LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS LTD.</small>	



E4662-1 CO-PILOT PANEL
AUXILIARY VIEW

RELEASED
2012-06-01

DESIGN	JS	EAGLE COPTERS LTD	
DRAWN	JS	CALGARY, ALBERTA, CANADA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	E4662	SHEET 2 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	N/A	INSTRUMENT PANEL	NTS
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